

Date: Friday, 21/11/2008 8:09:25 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BATTERY CASE TRAY		
Job Number	43079					
Estimate Number	11392					
P.O. Number	:		Part Number	D32611		
This Issue	21/11/2008	S.O. No. :	Drawing Number	D3261 REV A2		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	A2		
Previous Run	43079		Material	:		
Written By	<i>Jay</i> 08-11-21		Due Date	28/11/2008	Qty:	10 Um: Each
Checked & Approved By						
Comment	Est. B 04.12.02 Material no longer cut in-house KJ/JLM Est Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC					

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB750	UHMW .750 sheet <i>24 MAT NOT PULLED</i>
		
Comment: Qty.: 1.9950 sf(s)/Unit Total : 19.9500 sf(s) UHMW .750 sheet BATCH: 109986 <i>RB 8-11-21</i>		

2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3261 Dwg Rev: <u>A2</u> <i>RB 8-11-21</i> Prog Rev: <u>A2</u>		
		

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA421 Rev: <u>A2</u> & Dwg D3261 Rev: <u>A</u>		
		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>RB 8-11-21</i>		
		
M.A 08/10/24		

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Drawing Name: BATTERY CASE TRAY

Job Number: 43079

Part Number: D32611

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



MF 08/11/24

(12)

Comment: SECOND CHECK

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST137 / C 8/11/20 (12)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/26 AD

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-25

DART AEROSPACE LTD	Work Order:	43079
Description: Battery Case Tray (Dual Battery Rack)	Part Number:	D3261-1
Inspection Dwg: D3261 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	*IB			
18.00	+/-0.005	18.00	✓			
12.25	+/-0.030	12.25	*IB			
9.75	+/-0.030	9.750	✓			
1.27	+/-0.030	1.268	✓			
11.00	+/-0.030	11.006	✓			
Ø0.191	+0.005/-0.000	Ø 0.196	✓			
0.50	+/-0.010	0.505	✓			
0.49	+/-0.03	0.498	✓			
2.00	+/-0.010	2.003	✓			
10.00	+/-0.010	9.996	✓			
1.00	+/-0.010	1.003	✓			
2.13	+/-0.010	2.123	✓			
Ø0.386	+0.005/-0.000	0.388	✓			
4.00	+/-0.005	4.002	✓			
0.75	+/-0.030	0.762	✓			
0.125	-0.010/+0.030	0.140	✓			
0.55	+/-0.030	0.546	✓			
0.50	+0.000/-0.030	0.495	✓			
0.67	+0.000/-0.030	0.666	✓			

Measured by:	HB 8-11-24 H.A 8-11-24
Date:	08/11/24

Audited by:	JK
Date:	08/11/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	JK



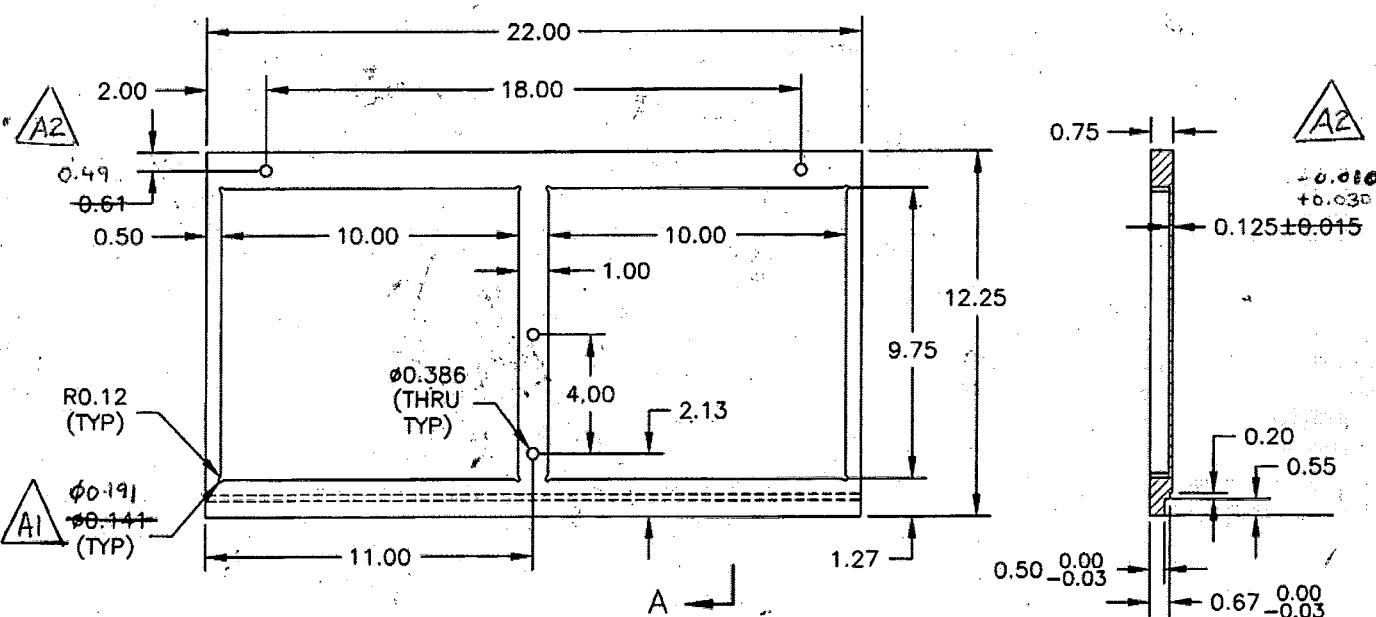
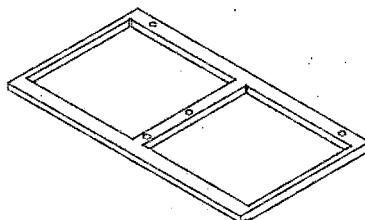


A circular stamp with the words "A COPY ISSUED" arranged in a circle.

DESIGN <i>JF</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>IP</i>	APPROVED <i>off</i>	DRAWING NO. D3261	REV. A SHEET 1 OF 1	
DATE 04.04.06	TITLE BATTERY CASE TRAY		SCALE 1:6	
A	04.04.06	NEW ISSUE		
A1	<i>IP</i> 04.05.14	Ø 0.191 WAS Ø 0.141		
A2	<i>JF</i> 04.06.08	0.125 ^{-0.010} WAS 0.125 ± 0.015; 0.49 WAS 0.61		

RELEASED
04-04-27 *[initials]*

04.04.27 4



~~UNDER REVIEW~~

D3261-1

DT. 04.06.25
THICKNESS CHANGE. 016 # 04.10.29

SECTION A-A

NOTES:

- NOTES:**

 - 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT

ND

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